

Date: Monday, 1/8/2007 10:50:35 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 30150B		
Estimate Number	: 10462		
P.O. Number	: N/A	Part Number	: D32782
This Issue	: 1/8/2007	S.O. No.	: N/A
Prsh Rev.	: NC	Drawing Number	: D3278 REV. B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29647B	Drawing Revision	: B
Written By	:	Material	: N/A
Checked & Approved By	: <u>dk</u> 07 01 08	Due Date	: 1/20/2007
Comment	: Est:A 04.04.19 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"  
		Comment: Qty.: 0.2454 f(s)/Unit Total : 12.2693 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Batch: <u>M19295/14PCS</u> <u>J.F. 07/01/14</u> <u>(50)</u>
2.0	SHEAR	SHEAR  
		Comment: <u>CUT</u> Bawn Saw Cut blank: 2.00" x 1.00" x 2.550" long  <u>J.F. 07/01/14</u> <u>(50)</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1  
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-2  <u>J.F. 07/01/15</u> <u>(50)</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE  <u>J.F. 07/01/15</u> <u>(50)</u>
5.0	QC8	SECOND CHECK  
		Comment: SECOND CHECK  <u>dk 07/01/14</u> <u>50</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: D1 Date: 07/01/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:50:36 AM  
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Drawing Name: SUPPORT

Job Number: 30150B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*MS/YL*

07/01/17

(50)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

~~FC~~ *Ex/a.m*

07/01/18

(50)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*FC* 07 01 8

(50)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*P7/01/18 50*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*L 07/01/19*

(50)

Job Completion



*u 07/01/19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30150B
Description: Support	Part Number:	D3278-2
Inspection Dwg: D3278 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

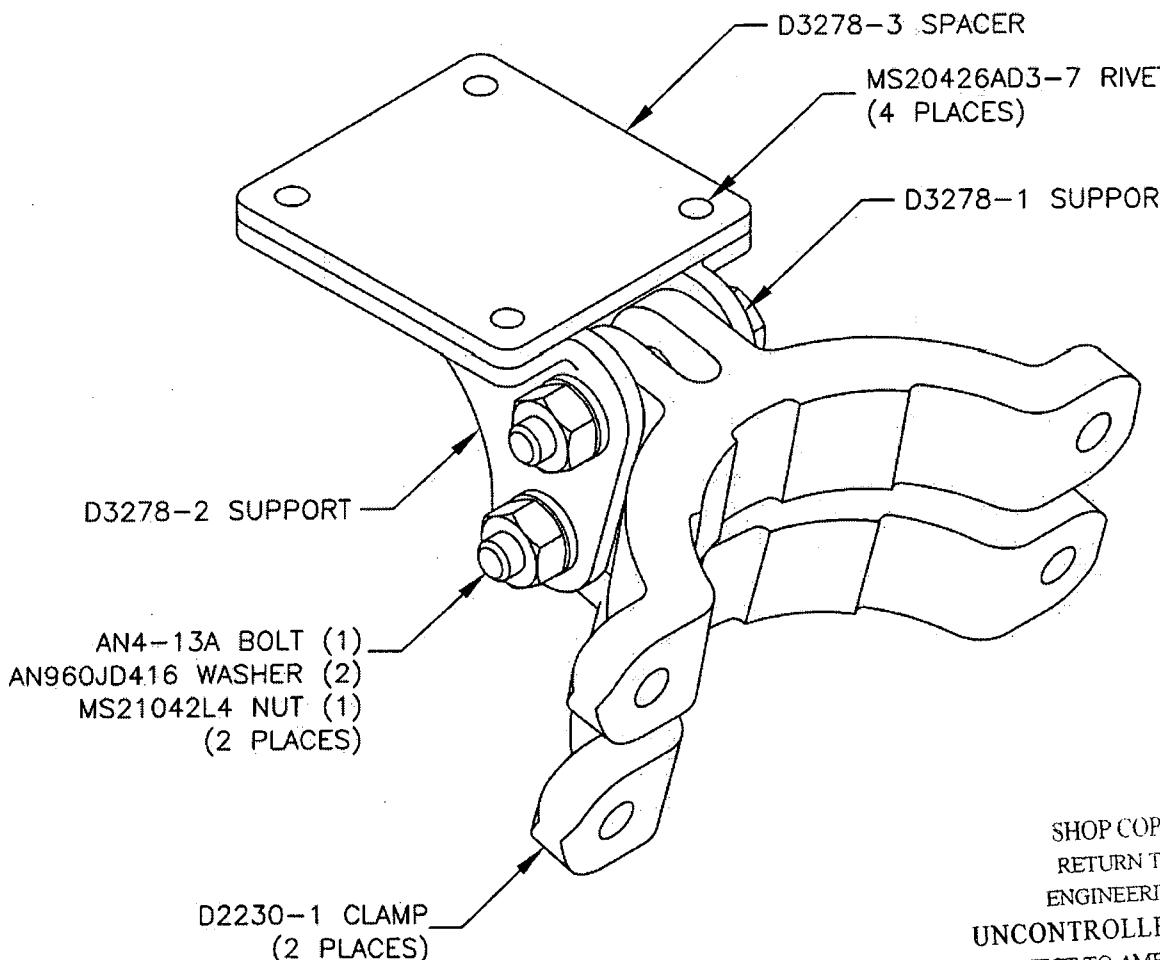
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø,099	✓			
0.359	+/-0.005	,362"	✓			
0.6	+/-0.010	,616"	✓			
0.250	+/-0.010	,251"	✓			
1.480	+/-0.005	1,485"	✓			
R0.125	+/-0.010	R0,125"	✓			
0.119	+0.005/-0.004	,120"	✓			
2.439	+/-0.010	2,439"	✓			
1.980	+/-0.010	1,979	✓			
R0.130	+/-0.010	R0,130"	✓			
Ø0.257	+0.005/-0.000	Ø,259"	✓			
R0.375	+/-0.010	,376"	✓			
0.875	+/-0.010	,876"	✓			
0.500	+/-0.010	,500"	✓			
R0.400	+/-0.010	R,400"	✓			
1.720	+/-0.010	1,721"	✓			
R0.125	+/-0.010	R0,125	✓			
0.125	+/-0.010	,126"	✓			

Measured by:	J.F.	Audited by:	SD	Prototype Approval:	N/A
Date:	07/01/14	Date:	07.01.14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	SJL

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

**RELEASED**  
05.04.04 - *[initials]*D3278-041 SUPPORT ASSEMBLY

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 30150B

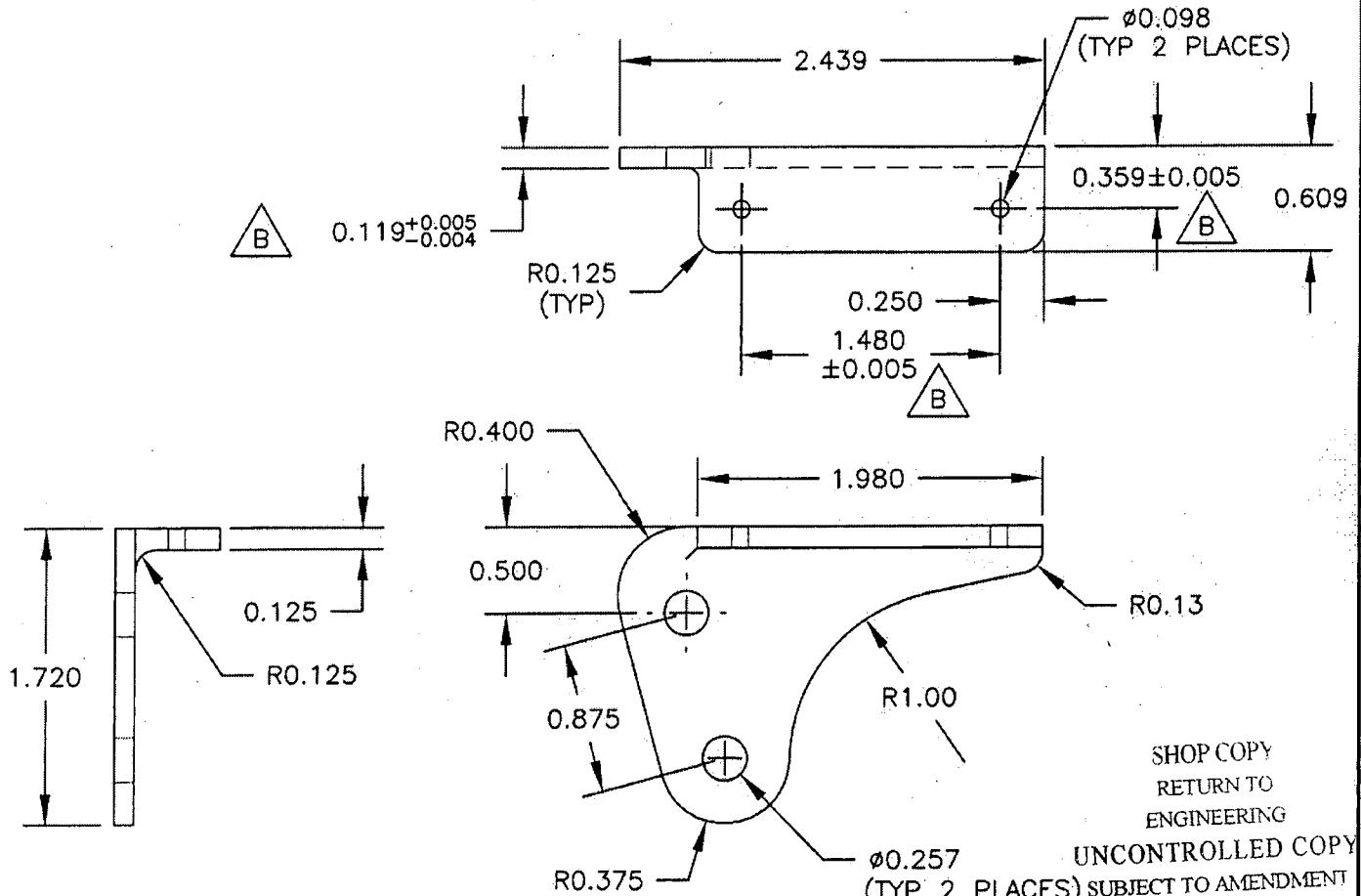
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY	REV. B SHEET 2 OF 3 SCALE 1:1

RELEASED

05.04.04 *[initials]*D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

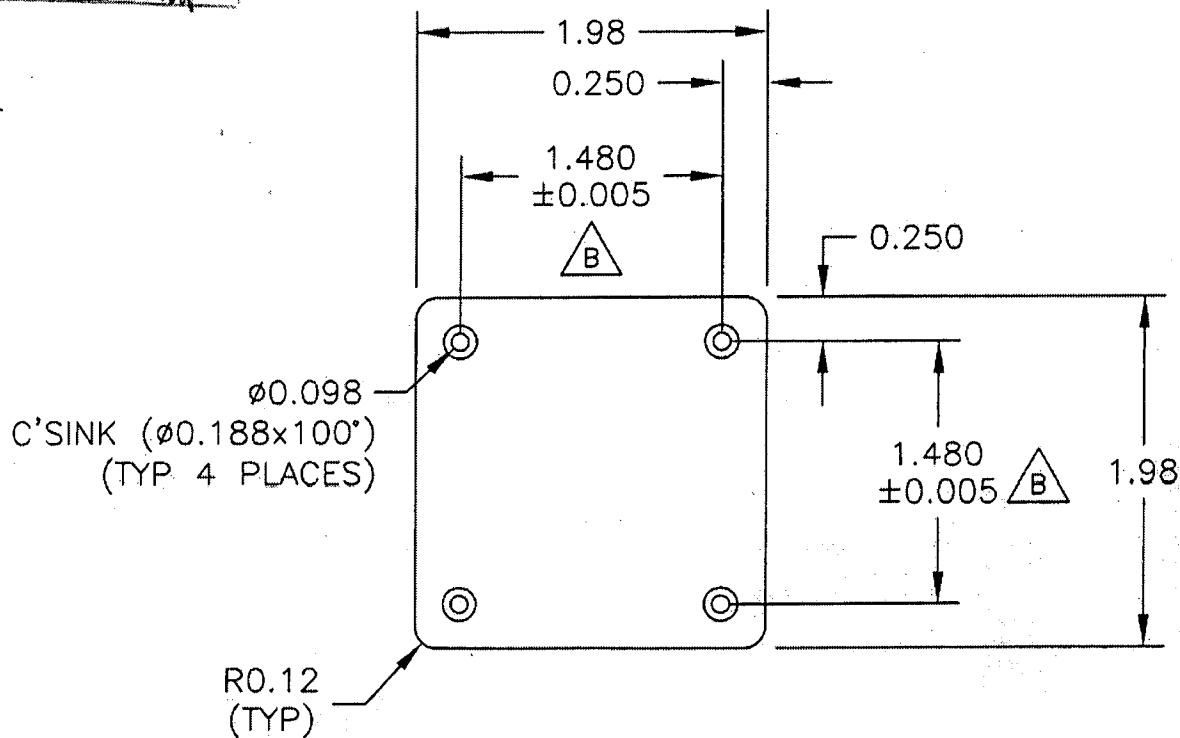
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31	TITLE SUPPORT ASSEMBLY	SCALE 1:1	

RELEASED

05.04.04 *[initials]*

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WITHOUT NOTICE  
WORK ORDER  
NO. 30150 B

D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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